

Work Order ID 64911

Page 1

Monday, January 03, 2011 8:25:11 AM

Item ID: D3272-1

Accept



Setup Start



Revision ID:

Item Name: Step

Stop



Start Date: 12/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-22-0 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty.	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	----------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3272	Rev B								

100

0.00



Large Fab

0.00

1/11.01.03 10 P

Large Fab	Memo								
-----------	------	--	--	--	--	--	--	--	--

SQUARE ONE END BEFORE CUTTING OTHER END

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110

0.00



QC6- Inspect dimensions to drawing

0.00

S 110 104

QC

0.00

Quality Control

(110)

Work Order ID 64911

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Monday, January 03, 2011 8:25:11 AM

Item ID: D3272-1

Accept



Setup Start



Revision ID:

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Stop



Start Date: 12/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: WPASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

11-01-04

10

P

0.00

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11-01-04

MF

10
11-01-04

Picklist Print

Page 1

Monday, January 03, 2011 8:25:23 AM

Work Order ID: 64911



Parent Item: D3272-1



Parent Item Name: Step

Start Date: 12/22/2010

Required Date: 1/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	37.7000	1	10		11/01/03	

Step Extrusion

Location	Loc Qty	Loc Code
WA	37.7	
55214	3.42	
58544	1	
61208	33.28	10

DART

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01		NEW ISSUE
B	07.05.18		D3272-1 WAS D2622-120

RELEASED

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

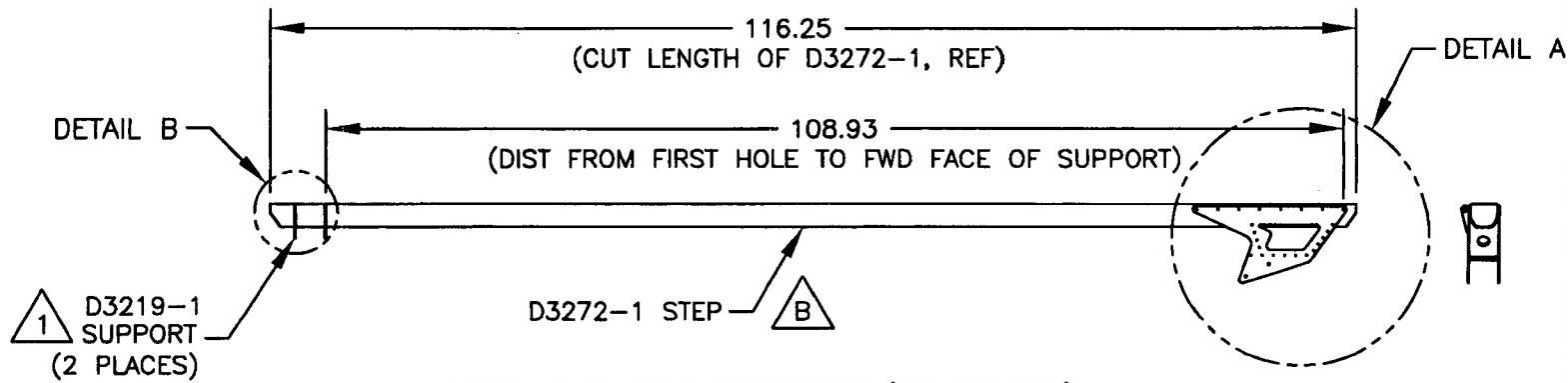
GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *64911*
BLCO 12-22

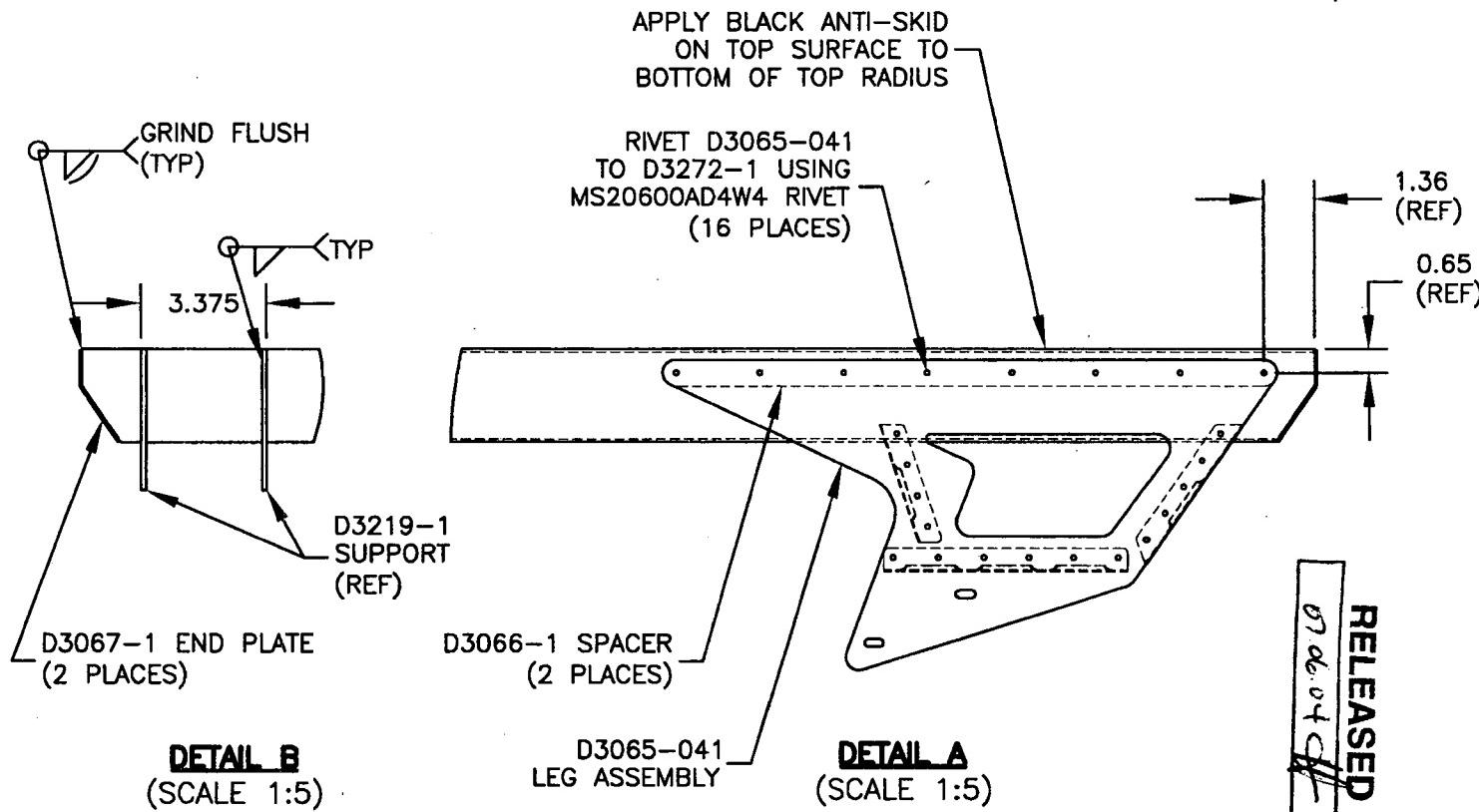
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D3272-041 STEP ASSEMBLY (LH, SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

W06494

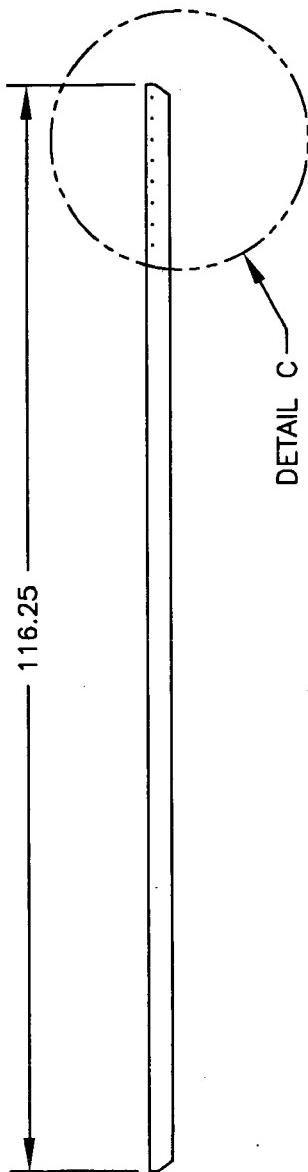


RELEASED
07 dec 04 C.H.

DESIGN	DRAWN BY	DART AEROSPACE LTD
97	J.B.	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
C.E.	M.H.	D3272
DATE		TITLE
07.05.18		STEP ASSEMBLY, LH LONG
SHEET	REV. B	SCALE
2 OF 3		1:20

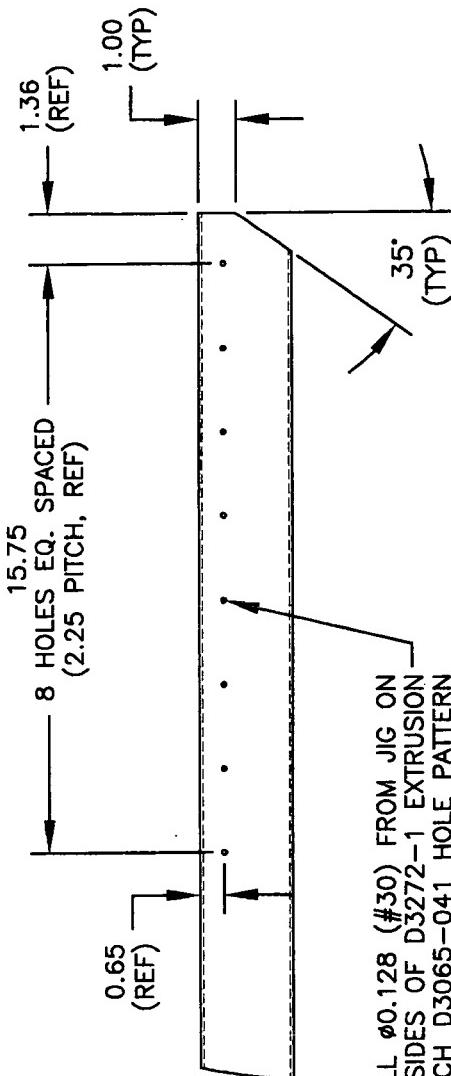
DART

DESIGN <i>GP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



△ **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)

WALL



DRILL #0.128 (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

RELEASED

07.06.04 *CH*

DETAIL C
(SCALE 1:5)

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